



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D3953-17

Job Sheet 199850



Part No: D3953-17

Job Qty: 40 pcs <sup>42 DAS</sup> <sub>21 9-59</sub>

Part Name: Gas Spring Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/3/19

Job Tracking No:

Due Date: 9/27/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation           | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|---------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                     |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Waterjet - Omax - 1 | 40 pcs | 9/27/19    | 9/27/19  | 0.17      | 4.00    | Waterjet - Omax       |           | 09/19/19 |
| 110   | QC 2                | 40 pcs | 9/27/19    | 9/27/19  | 0.00      | 0.00    | QC 2 - 1              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 12             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 14             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 17             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 19             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 2              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 20             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 22             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 23             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 25             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 32             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 33             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 35             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 39             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 4              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 40             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 44             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 45             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 48             |           | 09/19/19 |
|       |                     |        |            |          |           |         | QC 2 - 49             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 50             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 51             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 52             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 57             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 62             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 63             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 8              |           |          |
|       |                     |        |            |          |           |         | QC 2 - 66             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 64             |           |          |
|       |                     |        |            |          |           |         | QC 2 - 65             |           |          |

Plex 9/3/19 1:50 PM Dart.lajeunesse.marie

|     |                             |        |         |           |                       |  |
|-----|-----------------------------|--------|---------|-----------|-----------------------|--|
| 120 | QC 8                        | 40 pcs | 9/27/19 | 0.00 0.00 | QC 2 - 5              |  |
|     |                             |        |         |           | QC 2 - 71             |  |
|     |                             |        |         |           | QC 2 - 73             |  |
|     |                             |        |         |           | QC 2 - 69             |  |
|     |                             |        |         |           | QC 8 - 12             |  |
|     |                             |        |         |           | QC 8 - 14             |  |
|     |                             |        |         |           | QC 8 - 17             |  |
|     |                             |        |         |           | QC 8 - 20             |  |
|     |                             |        |         |           | QC 8 - 25             |  |
|     |                             |        |         |           | QC 8 - 3              |  |
|     |                             |        |         |           | QC 8 - 32             |  |
|     |                             |        |         |           | QC 8 - 33             |  |
|     |                             |        |         |           | QC 8 - 35             |  |
|     |                             |        |         |           | QC 8 - 39             |  |
|     |                             |        |         |           | QC 8 - 4              |  |
|     |                             |        |         |           | QC 8 - 44             |  |
|     |                             |        |         |           | QC 8 - 45             |  |
|     |                             |        |         |           | QC 8 - 49             |  |
|     |                             |        |         |           | QC 8 - 58             |  |
|     |                             |        |         |           | QC 8 - 8              |  |
|     |                             |        |         |           | QC 8 - 9              |  |
|     |                             |        |         |           | QC 8 - 68             |  |
|     |                             |        |         |           | QC 8 - 67             |  |
|     |                             |        |         |           | QC 8 - 1 (A)          |  |
|     |                             |        |         |           | QC 8 - 47             |  |
|     |                             |        |         |           | QC 8 - 40             |  |
|     |                             |        |         |           | QC 8 - 52             |  |
|     |                             |        |         |           | QC 8 - 23             |  |
|     |                             |        |         |           | QC 8 - 57             |  |
| 130 | Small Fab - 2 - B4B         | 40 pcs | 9/27/19 | 0.00 1.56 | Small Fab - 1 - B4B   |  |
|     |                             |        |         |           | Small Fab - 2 - B4B   |  |
|     |                             |        |         |           | Small Fab - 3 - B4B   |  |
|     |                             |        |         |           | Small Fab - 4 - B4B   |  |
|     |                             |        |         |           | Small Fab - 5 - B4B   |  |
|     |                             |        |         |           | Small Fab - 6 - B4B   |  |
|     |                             |        |         |           | Small Fab - 7 - B4B   |  |
|     |                             |        |         |           | Small Fab - 8 - B4B   |  |
| 140 | QC 5                        | 40 pcs | 9/27/19 | 0.00 0.00 | QC 5 - 10             |  |
|     |                             |        |         |           | QC 5 - 12             |  |
|     |                             |        |         |           | QC 5 - 17             |  |
|     |                             |        |         |           | QC 5 - 18             |  |
|     |                             |        |         |           | QC 5 - 19             |  |
|     |                             |        |         |           | QC 5 - 22             |  |
|     |                             |        |         |           | QC 5 - 24             |  |
|     |                             |        |         |           | QC 5 - 3              |  |
|     |                             |        |         |           | QC 5 - 43             |  |
|     |                             |        |         |           | QC 5 - 49             |  |
|     |                             |        |         |           | QC 5 - 51             |  |
|     |                             |        |         |           | QC 5 - 58             |  |
|     |                             |        |         |           | QC 5 - 68             |  |
|     |                             |        |         |           | QC 5 - 9              |  |
|     |                             |        |         |           | QC 5 - 50             |  |
|     |                             |        |         |           | QC 5 - 30             |  |
|     |                             |        |         |           | QC 5 - 40             |  |
|     |                             |        |         |           | QC 5 - 61             |  |
|     |                             |        |         |           | QC 5 - 81             |  |
| 150 | Packaging 3-1 - Stock - B4B | 40 pcs | 9/27/19 | 0.00 0.00 | Packaging 3 - 1 - B4B |  |
|     |                             |        |         |           | Packaging 3 - 2 - B4B |  |
|     |                             |        |         |           | Packaging 3 - 3 - B4B |  |

OCT 22 2019 40 8-89

|     |            |        |         |                        |      |                 |     |
|-----|------------|--------|---------|------------------------|------|-----------------|-----|
|     |            |        |         | Packaging 3 - 4 - B4B  | 7001 | 74 OCT 2 2 2019 |     |
|     |            |        |         | Packaging 3 - 5 - B4B  |      | 9-89            |     |
|     |            |        |         | Packaging 3 - 6 - B4B  |      |                 |     |
|     |            |        |         | Packaging 3 - 7 - B4B  |      |                 |     |
|     |            |        |         | Packaging 3 - 8 - B4B  |      |                 |     |
|     |            |        |         | Packaging 3 - 9 - B4B  |      |                 |     |
|     |            |        |         | Packaging 3 - 10 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 11 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 12 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 13 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 14 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 15 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 16 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 17 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 18 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 19 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 20 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 21 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 22 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 23 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 24 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 25 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 26 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 27 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 28 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 29 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 30 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 31 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 32 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 33 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 34 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 35 - B4B |      |                 |     |
|     |            |        |         | Packaging 3 - 36 - B4B |      |                 |     |
| 160 | QC 21 - SA | 40 pcs | 9/27/19 | 0.00                   | 0.00 | QC 21 - SA - 21 | DAS |
|     |            |        |         |                        |      | QC 21 - SA - 70 | 21  |
|     |            |        |         |                        |      | QC 21 - SA - 53 | 53  |

OCT 23 2019

Part Op 100 - 1-Cut as per Dwg D3953

Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)

120 - (QC8- Inspect parts - second check)

130 - (Small Fab) 1- OPEN HOLES AS PER DWG

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg &amp; Stock Location: \_\_\_\_\_)

160 - (QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item       | Component Name          | Quantity              | Operation               | Container |
|-------------------|-------------------------|-----------------------|-------------------------|-----------|
| M304B0.375X03.000 | M304 SS bar .375 x 3.00 | 1.2500 ft (.03125 ea) | 100-Waterjet - Omax - 1 | 5172181   |

## Job Allocations

| Operation               | Component Part    | Required | Inventory | Allocated |
|-------------------------|-------------------|----------|-----------|-----------|
| 100-Waterjet - Omax - 1 | M304B0.375X03.000 | 1        | 12        | 0         |

## Part Specifications

Specifications could not be found.

Plex 9/3/19 1:50 PM Dart.lajeunesse.marie





Entered: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

| DISPOSITION                                    |                                                                                                         | DEPARTMENT/PROCESS                                                                                             |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
|------------------------------------------------|---------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------|
| Job: _____                                     | Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/> | Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/> | Eng. (Non-AW)<br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec/Store/Packaging <input type="checkbox"/> | Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |
| Date: _____                                    | Sequence #: _____                                                                                       | QTY Affected: _____                                                                                            |                                                                                                                 | MRB (QS1042)                                                                                                |                                                                                                                                                     |
| Description Work Order Deviation               |                                                                                                         | Disposition                                                                                                    |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
|                                                |                                                                                                         | Completed By                                                                                                   |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
|                                                |                                                                                                         | Lead hand / Supervisor                                                                                         |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
|                                                |                                                                                                         | QC / QA Coordinator                                                                                            |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
|                                                |                                                                                                         |                                                                                                                |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
| Root Cause                                     |                                                                                                         | FAULT CATEGORY                                                                                                 |                                                                                                                 |                                                                                                             |                                                                                                                                                     |
| Operator <input type="checkbox"/>              | Pressure/Forced <input type="checkbox"/>                                                                | Contamination <input type="checkbox"/>                                                                         | Power Loss/Surge <input type="checkbox"/>                                                                       | Positioned Wrong <input type="checkbox"/>                                                                   |                                                                                                                                                     |
| Manufacturing Process <input type="checkbox"/> | Bending <input type="checkbox"/>                                                                        | Misaligned/off center <input type="checkbox"/>                                                                 | Folio/Program <input type="checkbox"/>                                                                          | Outside Tolerance <input type="checkbox"/>                                                                  |                                                                                                                                                     |
| Equip/Tooling <input type="checkbox"/>         | Crushing <input type="checkbox"/>                                                                       | BOM/Route <input type="checkbox"/>                                                                             | Grain Direction <input type="checkbox"/>                                                                        | Drawing <input type="checkbox"/>                                                                            |                                                                                                                                                     |
| Handling/Preservation <input type="checkbox"/> | Cracks <input type="checkbox"/>                                                                         | Broken/Damage/Defect <input type="checkbox"/>                                                                  | Weld <input type="checkbox"/>                                                                                   | Finish <input type="checkbox"/>                                                                             |                                                                                                                                                     |
| Material <input type="checkbox"/>              | Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/>                                                   | Incomplete/Unclear Instructions <input type="checkbox"/>                                                       | Wrong Stock Pulled <input type="checkbox"/>                                                                     | Part Lost/Missing <input type="checkbox"/>                                                                  |                                                                                                                                                     |
| Product Improvement <input type="checkbox"/>   | Marks/Chatter <input type="checkbox"/>                                                                  | Drill Holes <input type="checkbox"/>                                                                           | Out of Sequence <input type="checkbox"/>                                                                        | Misread <input type="checkbox"/>                                                                            |                                                                                                                                                     |
| Process Improvement <input type="checkbox"/>   | Mislabeled <input type="checkbox"/>                                                                     | Fit/Function <input type="checkbox"/>                                                                          | Off-set/Set-up <input type="checkbox"/>                                                                         |                                                                                                             |                                                                                                                                                     |
| Human Factors <input type="checkbox"/>         | Other/Details: _____                                                                                    |                                                                                                                |                                                                                                                 |                                                                                                             |                                                                                                                                                     |